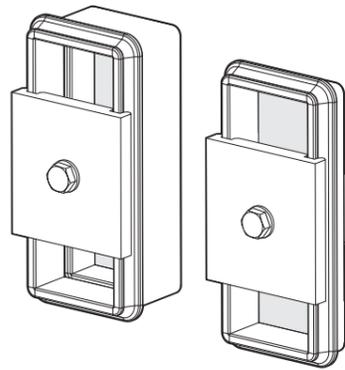


Installation instructions

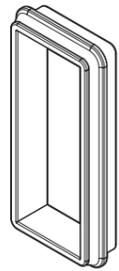
Roxtec C LW frame

Roxtec C LWK frame

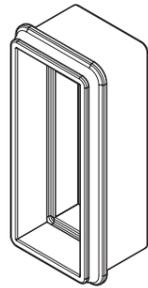
Roxtec welding fixture



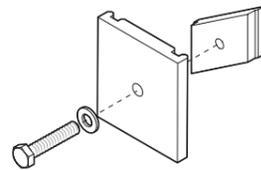
Components



Roxtec C LW frame
(sold separately)



Roxtec C LWK frame
(sold separately)



Roxtec welding fixture
(sold separately)

Energy input

The maximum allowed heat input is 0.8 kJ/mm.

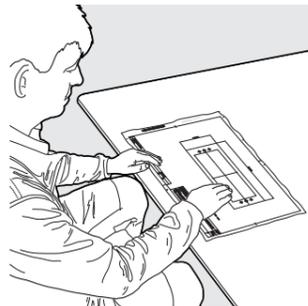
$$Q = \frac{k \times U \times I \times 60}{v \times 1000}$$

A	k
MIG/MAG	0.8
TIG	0.6

Q=Heat input (KJ/mm)
U=Voltage (V)
I=Current (A)
v=Welding speed (mm/min)
k=Thermal efficiency (dimensionless)

A=Welding method
k=Thermal efficiency

Additional information

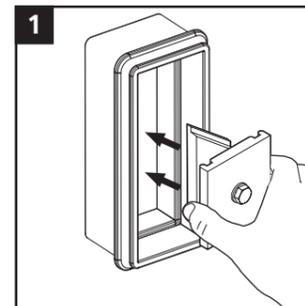


Visit roxtec.com for additional information such as drawings, aperture, videos, ratings and certificates.

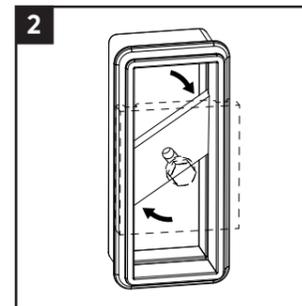
Tools

- Welding equipment (not included).
- Spanner (not included).

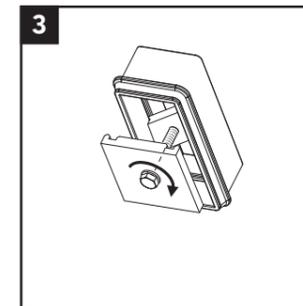
Attach welding fixture to C LWK frame



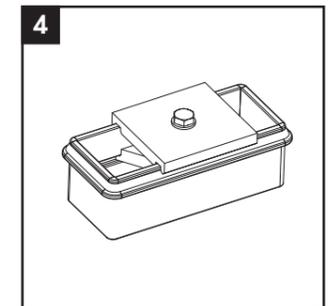
1 Insert the backpiece of the fixture.



2 Turn the backpiece into the slot of the frame.

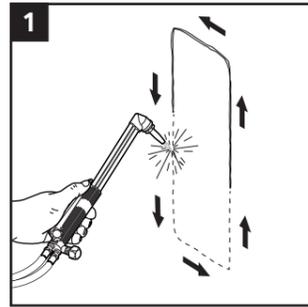


3 Tighten the screw.

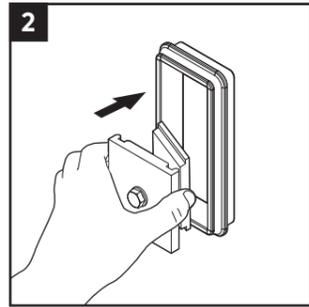


4 The C LWK frame ready for welding.

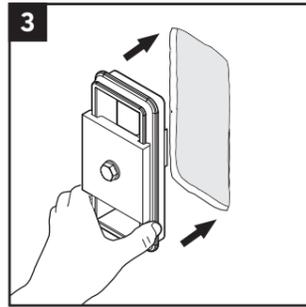
Installation



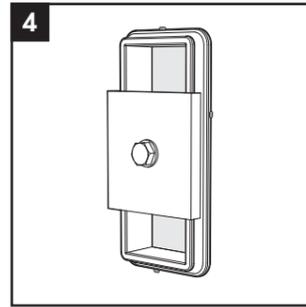
1 Make or verify an aperture.



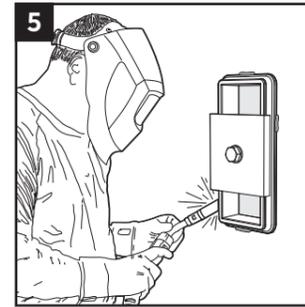
2 Attach the welding fixture to the frame.



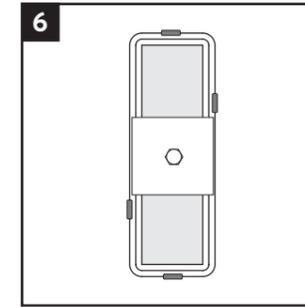
3 Insert the frame into the aperture.



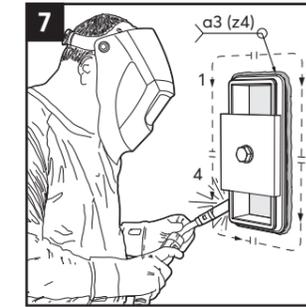
4 Fixate the frame in place.



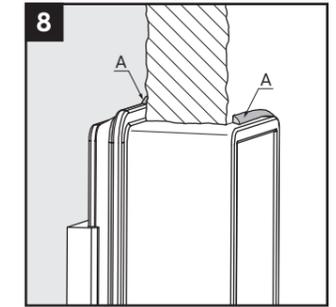
5 Tack weld the frame to the structure. Pre-heating of the frame to approx. 50°C is recommended.



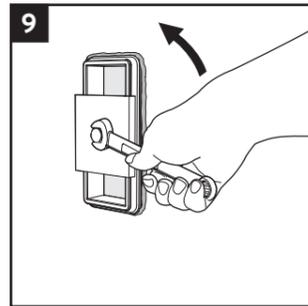
6 Place the tack welds like this.



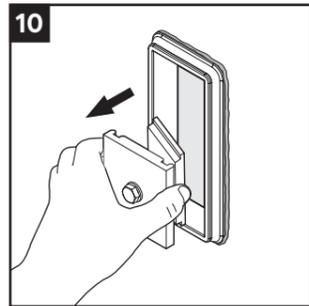
7 Tight weld the frame. Do not exceed an interpass temperature of 150°C. The weld runs shall not exceed 150 mm/weld pass.



8 Tight weld the frame from the backside, if required by design.



9 Wait until the temperature of the frame is below 50°C before untightening the screw of the welding fixture.



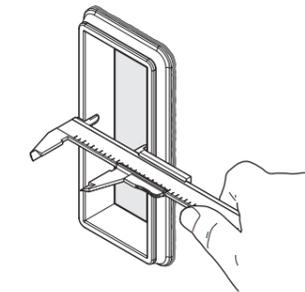
10 Remove the welding fixture.



11 Check additional documentation, if applicable.

After installation inspection

For optimum performance, keep within the dimensions in the table.



Measure 10 mm into the frame depth on the front side in accordance with the table after welding. The measurements are to be made with a frame or sleeve temperature below 50°C. Make sure not to tilt the caliper while measuring.

T	H (mm)	W (mm)
3	158-160	59.8-60.8
4	158-160	119.8-120.8
5	216-218	59.8-60.8
6	216-218	119.8-120.8
7	276-278	59.8-60.8

T. Frame type
H. Frame height
W. Frame width

Note

- Approvals or certificates may include amendments or limitations related to this application.
- The latest version of this and related documents are found at roxtec.com.

Disclaimer

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(b) Installation shall be carried out in accordance with Roxtec installation instructions in effect from time to time.

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